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102 25 198.3 6 June 2002 (06.06.2002) DE(71) Applicant (for all designated States except US): POLY-  
TYPE S.A. [CH/CH]; 26, route de la Glâne, case Postale  
1184, CH-1700 Fribourg (CH).

(72) Applicants and

(72) Inventors: ROESCH, Kurt [CH/CH]; 47, route des Mar-  
tinets, CH-1752 Villars-sur-Glâne (CH). TSCHUDI, Urs  
[CH/CH]; Brugerstr. 20, CH-3186 Düringen (CH).(74) Common Representative: MASCHINENFABRIK  
WIFAG; Wylerringstrasse 39, CH-3001 Bern (CH).

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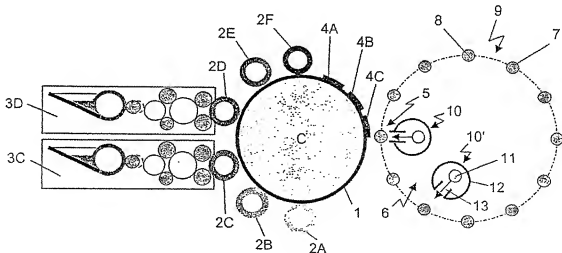
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(54) Title: PROCESS AND DEVICE FOR PRINTING A MULTICOLOR IMAGE



(57) Abstract: The present invention pertains to a process and to a device for printing a multicolor image composed of at least two varicolored partial images on a surface. A first partial image (4C) is transferred onto the surface in an ink transfer position (5) and at least a second partial image (4B) is transferred onto the surface in the same ink transfer position (5) and is superimposed to the first partial image. The partial images transferred onto the surface are dried (10) at least partially or hardened at least partially between the ink transfer steps. The drying step is carried out according to the present invention in the ink transfer position. High print quality can be achieved according to the present invention in a simple manner because the first partial image set and dried partially or also the respective additional, partially dried partial images always have well-defined surface properties. Essentially cylindrical bodies are preferably printed in multiple colors according to the present invention.

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### Process and Device for Printing a Multicolor Image

The present invention pertains to a process and a device for printing a multicolor image, especially a multicolor image composed of at least two different partial images, on a surface. An especially preferred application pertains to the printing of a multicolor image, e.g., a machine-readable bar code, on cylindrical, conical or comparably shaped containers, e.g., tubes, cans, glasses or the like.

Multicolor printing presses of model RDA12-100 and BDM916 of this class for providing cylindrical, conical or comparably shaped containers with multicolor images by means of an indirect high-pressure process, are known to the applicant. A rubber blanket cylinder is moved past printing plate cylinders and it takes over various partial images according to the wet-in-wet method and in good register, so that a total image composed of a plurality of partial images is formed on the rubber blanket. This total image is transferred to a surface to be printed on, for which purpose the container to be printed on rolls on a support mandrel in a rolling operation at the rubber blanket cylinder. To transfer the wet color image to the container, a certain pressing pressure of the rubber blanket is necessary, which leads to squeezing of the wet color image or to the enlargement of the dot in the printing gap by up to 40% and thus may lead to an impairment of the print quality.

Since only part of the print is transferred to the container during the transfer of the image and another part remains on the rubber blanket, which is moved past the plate cylinders for reinking, a certain amount of printing ink is returned in the overlapping area of varicolored partial images into the strand of rollers, which is intended for another printing ink.

The so-called ink setting, in which one or more partial images (of a different color) are set on the rubber blanket cylinder offset by the circumference of the container or by a multiple of the circumference and are thus transferred sequentially to the container, especially by rolling, is

known from the state of the art to minimize this ink return. Residual ink remaining on the rubber blanket after the image transfer therefore comes into contact with the plate cylinder of the particular ink only, so that no ink return into a strand of rollers intended for another printing ink occurs.

Since the wet partial image transferred onto the container is partially transferred from the container back onto the rubber blanket during a subsequent ink transfer operation, a certain return of the ink set from the container back to the rubber blanket will occur as well.

The multicolor image transferred to the container is not dried in the ink transfer position itself in the aforementioned printing presses, but only in a drying position arranged downstream of the ink transfer position, e.g., by UV irradiation or thermal drying.

A multicolor printing device that uses the ink setting technique is known from DE 198 07 924 A1. Containers held on support mandrels in a rotary revolver are moved sequentially past printing stations, where a partial image of an individual ink each is transferred. The partial images are transferred in different ink transfer positions. The partial image transferred onto the container is dried during the transfer to a next ink transfer position. The multicolor printing device has a comparatively complicated design and requires a lot of maintenance. In particularly, a comparatively large number of components, e.g., rubber blanket cylinders and drying devices, are necessary, and a complicated moving mechanism is needed to move the containers past the printing stations such that the partial images will be superimposed to form a total image in good register. The drying is performed in this multicolor printing device between two different ink transfer positions rather than in the ink transfer position.

Japanese Patent JP 05-096704 A discloses a multicolor printing device in which a plurality of printing stations are arranged sequentially along the outer circumference of a rotary revolver, which accommodates the cylindrical containers to be printed on. A drying device, which is

arranged at the corresponding ink transfer position, is associated with each printing station in this printing device. By rolling the containers past a corresponding rubber blanket cylinder, a partial image is transferred to the container. The partial image just transferred is dried on the side of a support mandrel facing away from the ink transfer position. The rotary revolver is subsequently moved on to a next ink transfer position. This multicolor printing device also has a comparatively complicated device and requires a lot of maintenance. The moving mechanism necessary for superimposing partial images in good register for the containers to be printed on is comparatively complicated.

The object of the present invention is to improve the state of the art forming this class, which was obviously used before, such as to make it possible to achieve high print quality with a simple and reliable printing process, especially in the case of printing on cylindrical or comparably shaped containers.

This object is accomplished by a process with the features according to claim 1 as well as by a process with the features according to claim 9. Advantageous variants are the subject of the subclaims that are referred back [to the principal claims].

In a process according to the present invention for printing a multicolor image, which is composed of at least two partial images of different colors, on a surface, at least a first partial image is transferred in an ink transfer position to the surface, and at least a second partial image is transferred to the surface in the same ink transfer position and is superimposed to the first partial image, and the partial images transferred to the surface are dried at least partially or are hardened at least partially in a drying step, the drying or hardening step being carried out with the printed surface in the ink transfer position. It is advantageous that the process and the method according to the present invention are comparably simple and not complicated, because the transfer of partial images takes place in the same ink transfer position. No expensive and complicated moving mechanism is therefore necessary to move the surface to be illustrated past the ink

transfer position. Because the particular partial image set is dried or hardened at least partially between the ink transfer steps, high print quality can be obtained according to the present invention in a simple manner. Since the transferred partial image set is dried or hardened at least partially, no ink is transferred from the surface back onto the rubber blanket cylinder any more. An ink other than the ink intended is thus prevented from being transferred back into inking mechanisms. In addition, it was possible to observe that the wet partial image to be transferred showed a smaller dot increase because of the partial drying of the partial image set.

Since the second partial image or the following partial images is/are transferred onto an at least partially dried or partially hardened partial image, the print quality as a whole can be increased, because the running into one another of partial images of different colors can thus be effectively ruled out. In addition, the ink transfer properties on an at least partially dried surface can be better controlled, so that it is possible to print especially total images rich in contrast in a simple manner according to the present invention, since the second and subsequent partial images are transferred to at least partially dried or at least partially hardened partial image with defined surface properties that can be preset in a simple manner (e.g., by selecting the drying conditions).

Furthermore, it is advantageous that the drying as a whole can be carried out more gently and more uniformly because the drying process is distributed among a plurality of individual steps, between which a repeated image transfer takes place. Excessive exposure to heat of the material of the body to be printed on can be avoided by selecting suitable drying parameters.

The first partial image is preferably a monochrome partial image, which consequently consists of only one color and does not already comprise partial images superimposed to one another itself. The second partial image to be transferred and each following partial image to be transferred may be monochrome or may be composed of a plurality of varicolored partial images superimposed to one another. The process according to the present invention is characterized by an advantageously high variability, because the composition of the partial images to be transferred

can be adapted to the print production according to the present invention in a simple manner. For example, the total number of partial images from which the second partial image to be transferred or a partial image to be transferred next is composed can be changed without any further changes in the design of the printing device. Since the second partial image to be transferred or the partial images to be transferred subsequently is/are always transferred onto a set partial image with defined surface properties, high print quality can always be achieved.

A partial image transferred onto the surface is dried or hardened at least partially according to the present invention. The surface layer of the transferred partial image that is responsible for the surface properties of the transferred partial image is consequently hardened or at least partially hardened and offers a defined surface for a subsequent ink transfer operation. Another parameter, which can be varied in a simple manner, and with which the print quality that can be achieved can be further optimized, is available in the printing process according to the present invention with the duration and intensity of the drying step.

The drying step is carried out according to the present invention in the ink transfer position, i.e., the printed surface is moved only insignificantly if at all from the ink transfer position for drying during the multicolor printing. The surface to be printed on is preferably mounted rotatably and rolls on the rubber blanket cylinder with the partial image to be transferred, which is located on it, during each ink transfer. The partial images on the rubber blanket cylinder are registered for the rotary movement of the surface to be printed on. The drying or initial hardening of a transferred partial image is preferably performed now on the surface in a position of the path, on which the surface is led between the individual ink transfer operations, which position is located directly downstream of the ink transfer position, e.g., opposite that position. In principle, the drying or initial hardening may, however, also take place exactly at the ink transfer position or in the immediate vicinity thereof, e.g., by irradiation or the admission of heat from a rear side of the surface to be printed on.

All partial images to be transferred are preferably transferred to the same rubber blanket cylinder, at which the surface to be printed on rolls synchronously with the circumferential movement of the rubber blanket cylinder. It is advantageous that a multicolor printing device of a relatively simple design requiring little maintenance can thus be obtained.

An especially preferred application pertains to the multicolor printing on cylindrical, conical or comparably shaped containers, e.g., tubs, cans or glasses. Such a body is preferably mounted rotatably movably around its longitudinal axis, so that the body can be rolled in the ink transfer position at the rubber blanket cylinder for the ink transfer. The body simply needs only to be rotated further by  $360^\circ$  for a subsequent ink transfer operation. An advantageously large angle range, in which a drying device can be arranged, is available for the intermediate drying or initial hardening step. The drying device is preferably arranged essentially offset by about  $180^\circ$  from the ink transfer position. The drying device may also span a larger angle range in order to achieve a gentle partial drying of a transferred partial image, e.g., by means of a large-area discharge opening of a drying device operating with warm air and/or radiation.

In a preferred multicolor printing device according to the present invention, a plurality of bodies to be printed on are held in a moving mechanism, which is designed to move a plurality of bodies sequentially past the ink transfer position. For printing on cylindrical or comparable bodies, the body is preferably mounted in a rotatably movable manner on a mandrel or a comparable rotatable mount, so that the body can roll at the rubber blanket cylinder for each ink transfer. The moving mechanism is preferably endless, e.g., it is designed as an endless belt or rotary revolver, where bodies to be printed on are introduced into the mechanism at an entry position, and printed-on bodies are removed from the mechanism in an unloading position.

To dry a transferred partial image at the ink transfer position, a drying device is preferably arranged in the immediate vicinity of the ink transfer position. The drying is preferably accelerated by the admission of heat and/or irradiation, especially UV irradiation. The admission

of heat and/or irradiation may be directed toward the surface of the body and/or it may take place from the rear side of the said body.

The drying device is preferably arranged on a side of a rotatable mount, e.g., a mandrel, for the body, which side is located opposite the ink transfer position, so that the body is alternately printed on at the ink transfer position during the performance of the rotary movement and is dried at least partially at the drying position located opposite the ink transfer position. The drying device may, in principle, also be arranged within the rotatable mount for the body to be printed on in order to admit heat and/or radiation to the printed-on surface from the rear side.

According to a preferred embodiment, the printed-on surface is dried at least partially at the drying position located directly opposite the ink transfer position by irradiation with light in the visible, infrared or preferably ultraviolet range. The drying device preferably comprises for this purpose a radiation source, especially an IR or UV light source, which is arranged in a reflector array surrounding the light source. The reflector array has an opening, which opens toward the drying position and from which the radiation can exit. An air flow, which may be discharged, in principle, from the aforementioned discharge opening and sweep over the printed-on surface, or is guided axially through the drying device to enter and exit at the front sides of the drying device, may flow through the drying device for removing heat.

Thermoplastic inks, which liquefy during heating above a softening or liquefaction point and are transferred in the liquid or softened state onto the surface to be printed on, are used for forming the partial image according to another preferred embodiment. The holding means for holding the surface to be printed on is preferably coolable, so that the transferred partial image can be cooled rapidly and overheating of the surface to be printed on can at the same time be effectively prevented from occurring. As an alternative or in addition, the printed-on surface may be cooled with a cooled gas flow, e.g., on the side of the rotatable mount or support mandrel located opposite the ink transfer position. A blower, a blowing chamber or the like for admitting a cooled



gas flow to the printed-on surface is provided for this purpose on the side of the rotatable mount or the support mandrel for holding the body with the surface to be printed on, which side is located opposite the ink transfer position.

The multicolor printing device according to the present invention preferably has an additional drying device, which is arranged in a position located downstream of the ink transfer position, in order to perform the final drying of the total image composed of a plurality of transferred partial images on the surface. It is advantageous that another body can already be printed on during the final drying, so that the throughput of the printing device can be increased.

Preferred embodiments of the present invention will be described below as examples and with reference to the attached drawings, in which

- Figure 1        schematically shows a cross-sectional view of a printing device according to the present invention;
- Figure 2        schematically shows an enlarged view of the ink transfer position and a drying device arranged at the ink transfer position; and
- Figure 3        schematically shows an enlarged view of the ink transfer position and a drying device arranged at the ink transfer position according to another embodiment of the present invention.

Identical reference numbers in the figures designate identical elements or assembly units or elements or assembly units with identical action. Figure 1 shows a schematic cross-sectional view of a multicolor printing device according to the present invention. The printing device comprises a rubber blanket cylinder 1, around the outer circumference of which a plurality of inking mechanisms 3, of which only two inking mechanisms 3C, 3D are shown in cross section

for clarity's sake, are arranged at spaced locations from one another. Partial images to be transferred are inked on the plate cylinder 2A-F by means of the inking mechanisms having a usual design, and they are transferred from there to the outer circumferential surface of the rubber blanket cylinder 1. A plurality of partial images 4A-C are thus formed sequentially and at spaced locations from one another on the outer circumferential surface of the rubber blanket cylinder 1. The partial images to be transferred may be monochrome. A second partial image and partial images 4B, 4A to be transferred thereafter may also be multicolored, i.e., consist of a plurality of partial images, which are superimposed wet in wet and shall be transferred to the body 7 to be printed on in a single ink transfer step.

The printing device comprises, moreover, a moving mechanism 9 to transport a plurality of bodies 7 to be printed on sequentially to the ink transfer position 5. According to Figure 1, the moving mechanism is designed as a rotary revolver. However, the moving mechanism 9 is not limited to a rotary revolver rotating in a circularly symmetrical manner, but it may also be led endlessly in another manner or may be essentially linear. The moving mechanism 9 comprises an entry position, not shown, in which the bodies 7 to be printed on are introduced into the moving mechanism 9, as well as an unloading position, not shown, where printed-on bodies 7 are again removed from the moving mechanism 9.

In Figure 1, the rotary revolver 9 rotates counterclockwise. According to Figure 1, the moving mechanism 9 is designed for printing on cylindrical, conical or comparably shaped, e.g., slender bodies. The rotary revolver 9 comprises for this purpose a plurality of rotatable mounts 8 for the bodies 7 to be printed on. In Figure 1, each body 7 is placed on a support mandrel 8, which can be driven by means of a rotating drive, not shown. The velocity of the rotating drive is selected such that the surface to be printed on is rolled synchronously with the circumferential velocity of the outer circumferential surface of the rubber blanket cylinder 1 at the rubber blanket cylinder at the ink transfer position 5.

A drying device 10 is arranged at the ink transfer position 5 in order to dry a partial image

transferred onto the body 7 to be printed on the side of the support mandrel 8 located opposite the ink transfer position 5. The body 7 to be printed on is thus rotated several times by means of the support mandrel 8 at the ink transfer position 5, and a drying step takes place between each ink transfer operation at or in the immediate vicinity of the ink transfer position 5.

After the transfer of the intended number of partial images to the body 7, the rotary revolver 9 is turned further counterclockwise to the drying position 6 located downstream of the ink transfer position 5, where another drying device 10' is provided to dry the total image transferred onto the body 7.

Thus, a multicolor printing process according to the present invention comprises the following steps: A first partial image 4C is transferred to a rubber blanket cylinder 1. At least one additional partial image 4B is subsequently transferred to the outer circumference of the rubber blanket cylinder 1. The second partial image and each additional transferred partial image may be monochrome or comprise a plurality of preferably varicolored partial images, which are superimposed to one another. The partial images 4A-C on the rubber blanket cylinder 1 are offset in relation to one another. The circumferential distance between the partial images 4A-C is preferably selected to be such that it corresponds to the outer circumference or a multiple integer of the said outer circumference of the body 7 to be printed on, so that the support mandrel 8 is rotated synchronously with the speed of rotation of the rubber blanket cylinder 1 for the transfer of the partial image in good register.

A body 7 to be printed on is moved to the ink transfer position 5 by means of the moving mechanism 9. To transfer the first partial image 4C, the body 7 seated on the support mandrel 8 rolls on the outer circumference of the rubber blanket cylinder 1 and takes up the first partial image 4C in the process. During the further rotation of the body 7, the said body is moved past the drying device 10, where the first partial image 4C is dried at least partially. The rubber blanket cylinder 1 rotates further at the same time in order to transport the next partial image 4B

transferred to the ink transfer position 5. During the further rotation of the body 7, the first partial image 4C, which was transferred to the body 7 and was dried at least partially, will again reach the ink transfer position 5, where the superimposition of the partial images 4B, 4C will subsequently take place in good register. This operation, which comprises alternatingly ink transfer steps and drying steps, is repeated until the last partial image 4A of the partial images to be transferred has been transferred to be body 7.

The body 7 is then transferred by means of the moving mechanism 9 to the drying position 6 arranged downstream of the ink transfer position 5, where the final drying of the total image takes place. The printed-on body 7 is finally removed from the moving mechanism 9 at an unloading position, not shown.

More layers, e.g., a transparent coat, may, of course, be transferred to the total image to increase the gloss or to form additional barrier properties. Such additional layers may likewise be transferred to the body 7 by means of the rubber blanket cylinder 1 or with an additional printing device, not shown, which is arranged between the ink transfer position 5 and the drying position 6 or downstream of the drying position 6.

The drying of the partial image and/or the total image is preferably carried out by means of a contactless energy source, which operates with the admission of heat and/or irradiation, especially in the visible, infrared or ultraviolet spectral range. Suitable drying devices are known to the person skilled in the art in this area.

The drying device 10, 10' schematically shown in Figure 1 comprises a light source 11 operating in the desired spectral range, which is arranged in a reflector array 12 surrounding the light source 11. The reflector array 12 is opened at least in the area of an outlet opening 13, from which the radiation and/or the air flow exits from the drying device 10, 10' in order to reach the printed-on surface of the body 7.

The reflector array 12 is preferably designed at least in some sections as a concave mirror, e.g., as a spherical concave mirror or a paraboloid concave mirror in order to reflect the radiation emitted by the light source 11 on the printed-on surface. The light source 11 may be arranged to this end in the focal point of the concave mirror, so that the radiation exits the outlet opening 13 of the drying device 10, 10' essentially as a parallel ray beam.

To remove heat, an air flow may flow through the reflector array 12, which air flow is led, e.g., axially, i.e., essentially in parallel to the longitudinal axis of the body 7 to be dried and enters and leaves on the front sides of the drying device 10, 10', or exits from the outlet opening 13, to sweep over the surface of the body 7 to be dried, in order to additionally accelerate the drying operation.

Although not shown in the figures, the drying may also take place from the rear side of the surface to be dried, especially by the admission of heat and/or irradiation from the rear side of the body 7. A drying device, e.g., a radiation source, may be provided for this purpose in each support mandrel 8. The support mandrel may be cooled (see below) in case of the of hot melt inks.

Figure 2 shows an enlarged perspective cross section of the elements arranged in the vicinity of an ink transfer position 5. The outlet opening 13 of the reflector array 12 has a nozzle-like design and faces a side of the support mandrel 8 that faces away from the ink transfer position proper. The ink transfer and the drying of the ink thus take place alternatingly in essentially opposite angular positions of the support mandrel 8. The support mandrel 8 has a diameter  $D$ , so that the distance between two consecutive partial images 4B, 4C on the outer circumferential surface of the rubber blanket cylinder 1 corresponds to the outer circumference of the body 7 to be printed on, which can be calculated from  $D$ , or to an integer multiple thereof.

The support mandrel 8 may be cooled in the above-described embodiments, e.g., a cooled gas

flow or a cooling liquid may flow through it to effectively prevent the body to be printed on from overheating.

The process according to the present invention may also be applied readily to inks other than those to be applied in the liquid or pasty form to form the partial images. This is illustrated on the basis of Figure 3, which schematically shows another embodiment of the present invention, in which the so-called hot melt inks are used. These types of thermoplastic inks are based on a high fat content, which may reach up to 100%, and which are liquefied or softened by heating, e.g., to about 150°C-180°C, so that the partial images thus liquefied or softened can be transferred to the bodies 7 to be printed on in the above-described manner. The hot melt ink transferred to the body 7 cools rapidly and hardens in the process in order to form an at least partially dried partial image. This cooling may be advantageously supported by additional measures.

To harden hot melt inks, the support mandrel shown in Figure 3 may be precooled in the known manner, e.g., by a cooled gas flow or a cooling liquid, so that the round body 7 placed on the support mandrel 8 is also cooled on its way to the ink transfer position 5. The pasty hot melt-like printing ink begins to solidify immediately on the round body 7 during the transfer of the first partial image 4C.

The cooling of the transferred partial image may also be supported by admitting a cooled gaseous flow 15, e.g., cooled air, to the surface of the body 7. As is shown in Figure 3, a blower 14 is provided for this purpose. The blower 14 may be designed as a blow box, with a housing wall and a discharge opening 13 in order to direct the cooled gas flow toward the printed surface of the round body 7 in a directed manner. The blower is preferably arranged on the side of the support mandrel 8 located opposite the ink transfer position.

The transferred partial image is thus cooled and sufficiently hardened on the side of the support mandrel 8 located opposite the ink transfer position 5. The subsequent transfer of the partial

images 4B and 4A takes place analogously to the solidified or at least partially dried surface of the round body 7.

A preferred application pertains to the multicolor printing on cylindrical, conical or comparably shaped slender bodies, e.g., tubes, cans, glasses and the like, especially preferably bodies made of plastics, especially transparent plastics. A monochrome color image or even a bonding agent (primer) may be set with the first partial image and dried at least partially before an ink application proper, without an additional application station or a separate run through the press being necessary for this.

A machine-readable bar code is especially preferably printed with the process according to the present invention, for which purpose a preferably white ink field is set first, and the bar code is printed on it.

Especially in the case of transparent bodies, the first partial image may also ensure only a monochrome color background, on which at least one additional partial image or preferably a multicolor total image is printed after partial drying. It is possible according to the present invention to apply an intensely pigmented, thick overall ink layer by means of dry two-layer or more than two-layer ink layers applied in advance.

The process according to the present invention is, of course, also suitable for printing on any other surfaces, e.g., of labels, signs and/or any bodies, containers or the like.

### Patent Claims

1. Process for printing a multicolor image, which is composed of at least two said varicolored partial images (4A-C), on a said surface (7), in which process
  - at least a first partial image is transferred onto the surface in a said ink transfer position (5), and
  - at least a second partial image is transferred to the surface in the same said ink transfer position (5) and is superimposed to the first partial image, wherein
  - the transferred partial images are dried at least partially or hardened at least partially in a drying step,  
**characterized in that** the drying or initial hardening step is carried out in the said ink transfer position (5).
2. Process in accordance with claim 1, in which all said partial images (4A-C) are transferred to the said same rubber blanket cylinder (1).
3. Process in accordance with claim 1 or 2, in which said partial images (4A-C) are applied in circumferential positions of the said rubber blanket cylinder (1) which are offset in relation to one another.
4. Process in accordance with one of the above claims, in which the said surface (7) is moved past the said ink transfer position (5) synchronously with a circumferential movement of the said rubber blanket cylinder (1) for the ink transfer.
5. Process in accordance with one of the above claims, in which the surface is arranged on the outer circumference of a body, especially an essentially cylindrical body, wherein the body is mounted rotatably movably around a longitudinal axis and is rotated around its



longitudinal axis each time for the ink transfer in the said ink transfer position (5).

6. Process in accordance with claim 5, in which the said surface (7) is moved farther, preferably essentially by 180°, from the said ink transfer position (5) for drying or partial hardening between two ink transfer steps.
7. Process in accordance with claim 5 or 6, in which the partial images are formed by liquefying thermoplastic color images, wherein the said, rotatably movably mounted body (8) [sic - Tr.Ed.] is cooled and/or a cooled gas flow is blown onto the said surface (7) between two ink transfer steps.
8. Process in accordance with one of the above claims, in which a plurality of bodies are held in a said rotary revolver (9) in order to be transported to the said ink transfer position (5), wherein the multicolor image composed of a plurality of transferred partial images is dried in a position arranged downstream of the said ink transfer position (5) in a final drying step.
9. Process in accordance with one of the above claims, in which a monochrome partial image, especially with uniform color intensity, is transferred to the said surface (7) in a first ink transfer step, and a monochrome partial image or a partial image composed of a plurality of varicolored partial images, especially a bar code, is transferred to the at least partially dried monochrome partial image in a second ink transfer step.
10. Device for printing a varicolored image, which is composed of at least two said varicolored partial images (4A-C), on a said surface (7), comprising
  - a said ink transfer mechanism (2) to transfer at least a first partial image to the said surface (7) in a said ink transfer position (5) and to transfer at least a second partial image to the said surface in the same said ink transfer position (5) and to

superimpose it to the first partial image, and

- a said drying device (10) to partially dry or partially harden the transferred partial images,

**characterized in that** the said drying device (10) is arranged at the said ink transfer position (5).

11. Device in accordance with claim 10, wherein the ink transfer mechanism comprises a said rubber blanket cylinder (1), onto which all said partial images (4A-C) are transferred.
12. Device in accordance with claim 10 or 11, in which a control device is provided to apply the said partial images (4A-C) in circumferential positions of the said rubber blanket cylinder (1) which are offset in relation to one another in good register.
13. Device in accordance with one of the claims 10 through 12, also comprising a said carrying device (8) to carry the said surface (7) and to move it past the said ink transfer position (5) synchronously with a circumferential movement of the rubber blanket cylinder for the ink transfer.
14. Device in accordance with one of the claims 10 through 13, in which the carrying device comprises at least one said mandrel (8) mounted rotatably movably around its longitudinal axis for holding a said, essentially cylindrical body (7), wherein the said body is rotated around its longitudinal axis in the said ink transfer position (5) for transferring the ink.
15. Device in accordance with claim 13 or 14, in which the said drying device (10) is arranged on a side of the said carrying device (8) located opposite the said ink transfer position (5), wherein the carrying device is designed to rotate the said surface (7) further, preferably essentially by 180°, from the said ink transfer position (5) to the said drying device (10) for drying or partial hardening between two ink transfer steps.

16. Device in accordance with claim 14 or 15, in which the said carrying device (8) is coolable and/or a said blowing device (14) is provided between two ink transfer steps for drying a partial image to blow a cooled gas flow onto the said surface (7) in order to cool partial images formed by the liquefaction of thermoplastic color images.
17. Device in accordance with one of the claims 10 through 15, in which the said drying device comprises a said light source (11), especially a UV light source.
18. Device in accordance with claim 17, in which the light source comprises a said reflector (12) with a said outlet opening (13) to reflect light emitted by the said light source (11) through the said outlet opening (13) on the partial image to be dried.
19. Device in accordance with claim 18, in which the said light source (11) of the said drying device (10) is cooled by an air flow, which is discharged through the said outlet opening (13) to sweep over the partial image to be dried, or is led axially past the said light source (11) and enters and leaves on front sides of the said drying device (10).
20. Device in accordance with one of the claims 10 through 19, in which a plurality of bodies, especially said, essentially cylindrical bodies (7), are held in a said rotary revolver (9) to be transported to the said ink transfer position (5), wherein a said additional drying device (10') is provided in a position arranged downstream of the said ink transfer position (5) to dry the multicolor image composed of a plurality of transferred partial images at least partially in the said downstream drying position (6) in a final drying step.
21. Device in accordance with one of the claims 10 through 20, which is designed to transfer a monochrome image, especially with uniform color intensity, onto the said surface (7) in a first ink transfer step and to superimpose a monochrome partial image or a partial image

composed of a plurality of varicolored partial images, especially a bar code, to the at least partially dried monochrome partial image in a second ink transfer step.

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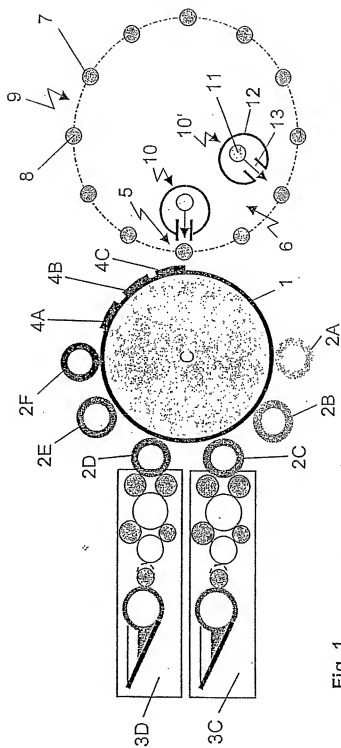


Fig. 1

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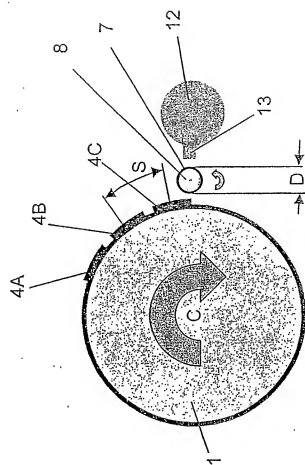


Fig. 2

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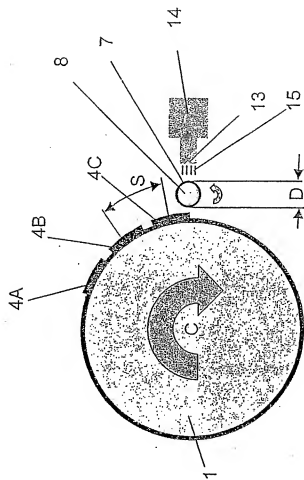


Fig. 3

A. CLASSIFICATION OF SUBJECT MATTER IPC 7 B41F17/22		
According to International Patent Classification (IPC) or to both national classification and IPC		
B. FIELDS SEARCHED Minimum documentation searched (classification system followed by classification symbols) IPC 7 B41F		
Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched		
Electronic data base consulted during the international search (name of data base and, where practical, search terms used) PAJ, EPO-Internal		
C. DOCUMENTS CONSIDERED TO BE RELEVANT		
Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A, P	DE 101 08 753 A (DOROW JOACHIM) 5 September 2002 (2002-09-05) the whole document	1, 10
A	PATENT ABSTRACTS OF JAPAN vol. 018, no. 258 (M-1606), 17 May 1994 (1994-05-17) & JP 06 040007 A (NIPPON KIYOKUMEN INSATSU KENKYUSHO:KK), 15 February 1994 (1994-02-15) abstract	1, 10
<input type="checkbox"/> Further documents are listed in the continuation of box C. <input checked="" type="checkbox"/> Patent family members are listed in annex.		
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Date of the actual completion of the international search 12 August 2003		Date of mailing of the international search report 20/08/2003
Name and mailing address of the ISA European Patent Office, P.B. 5618 Patentlaan 2 NL - 2260 HV Rijswijk Tel. (+31-70) 340-2040, Tx. 31 651 epo nl, Fax (+31-70) 340-3016		Authorized officer Loncke, J



Patent document cited in search report		Publication date	Patent family member(s)		Publication date
DE 10108753	A	05-09-2002	DE	10108753 A1	05-09-2002
JP 06040007	A	15-02-1994	NONE		

A. KLASSIFIZIERUNG DES ANMELDUNGSGEGENSTANDES IPK 7 B41F17/22		
Nach der internationalen Patentklassifikation (IPK) oder nach der nationalen Klassifikation und der IPK		
B. RECHERCHIERTE GEBIETE Forschelter Mindestprüfstoff (Klassifikationssystem und Klassifikationssymbole) IPK 7 B41F		
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Während der internationalen Recherche konsultierte elektronische Datenbank (Name der Datenbank und evtl. verwendete Suchbegriffe) PAJ, EPO-Internal		
C. ALS WESENTLICH ANGESEHENE UNTERLAGEN		
Kategorie*	Bezeichnung der Veröffentlichung, soweit erforderlich unter Angabe der in Betracht kommenden Teile	Betr. Anspruch Nr.
A, P	DE 101 08 753 A (DOROW JOACHIM) 5. September 2002 (2002-09-05) das ganze Dokument	1, 10
A	PATENT ABSTRACTS OF JAPAN vol. 018, no. 258 (M-1606), 17. Mai 1994 (1994-05-17) & JP 06 040007 A (NIPPON KIYOKUMEN INSATSU KENKYUSHO:KK), 15. Februar 1994 (1994-02-15) Zusammenfassung	1, 10
<input type="checkbox"/> Weitere Veröffentlichungen sind der Fortsetzung von Feld C zu entnehmen <input checked="" type="checkbox"/> Siehe Anhang Patentfamilie		
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Im Recherchenbericht angeführtes Patentedokument		Datum der Veröffentlichung	Mitglied(er) der Patentfamilie	Datum der Veröffentlichung
DE 10108753	A	05-09-2002	DE 10108753 A1	05-09-2002
JP 06040007	A	15-02-1994	KEINE	